1 CLEAN
Clean and degrease the body panel to be repaired.

2 STRAIGHTEN PANEL
Straighten the panel to be repaired as needed.

3 PAINT REMOVAL
Remove the old paint and base coat with 80 grit in the area to be filled.

4 PREPARATION
Sand and featheredge the area with 80 - 180 grit, then remove the sanding dust with clean compressed air.

5 APPLY FILLER OR QUANTUM1™
Apply Evercoat Filler with even, firm pressure in a thin coat, then apply additional material as needed.

6 SAND & FEATHEREDGE
Sand the filler to shape with 80 - 180 grit, then final sand and featheredge with 180 grit. Remove sanding dust with clean compressed air.

7 APPLY PUTTY
Apply a thin coat over the entire repair with even, firm pressure to provide a primer-like finish. NOTE: Rage Ultra or Quantum can be applied as its own putty coat if needed.

8 SAND
Sand and featheredge the repair with 180 grit.

9 INSPECT
Inspect the repair area for sand streaks, pinholes, or imperfections.

10 APPLY 440 EXPRESS™
Use sponge to apply 440 Express over entire repair surface. NOTE: This is optional. To assure a smooth, pinstripe free surface every time, apply 440 Express.

CAUTION: Before beginning aluminum repairs, be sure to have the proper tools, equipment, and defined work area to conduct these and all aluminum repairs. Check the vehicle manufacturer for specific repair recommendations. It is not recommended to use tools and/or abrasives that have been previously used on ferrous metals for the repair of aluminum. Doing so can cause cross contamination and create the possibility of corrosion.
RECOMMENDED ALUMINUM PRODUCTS

Metal-2-Metal™ 100889
- Excellent for high-stress areas and where objects will be mounted
- Resists “compression” when drilling and mounting objects
- Seam-to-seam welded repairs
- Will not sag
- Easily sands to fine featheredge
- 100% stain free
- High-strength resin and pure aluminum ensures optimum strength and impact resistance vs. the leading competition.

Panel Bond
106030, 106045, 100813, & 100815
These 4 products are a one-to-one epoxy adhesive used for replacing door skins, roofs, quarter panels, truck bedides, utility vehicle sides and other non-structural panels. These two have excellent adhesion to aluminum and e-coats and is backed with a lifetime warranty by Evercoat.

OEM Bead 106022 & 100822
OEM Bead is a two-component epoxy seam sealer used to duplicate a variety of OEM seams. This non-sag seam sealer has excellent bonding characteristics and it is compatible with most topcoats.

Control Flow 106023 & 100823
Control Flow Seam Sealer is an epoxy seam sealer with limited flow characteristics, ideal for use in sealed areas. The viscosity of this seam sealer allows for build without brush marks. Control Flow Seam Sealer is compatible with most topcoats.